

NAVSHIPREPFAC YOKOSUKA
LOCAL STANDARD ITEM

FY-01

ITEM NO: 099-55YO
DATE: 24 NOV 2000
CATEGORY: II

1. SCOPE:

1.1 Title: Regulating/Reducing Valve; repair

2. REFERENCES:

- a. T9074-AS-GIB-010/271, Requirements for Nondestructive Testing Methods
- b. MIL-STD-2035, Nondestructive Testing Acceptance Criteria

3. REQUIREMENTS:

3.1 Matchmark valve parts.

(V) "INSPECT PARTS FOR DEFECTS"

3.2 Disassemble, clean internal and external surfaces free of foreign matter (including paint), and inspect parts for defects.

(I) "LIQUID PENETRANT INSPECT" (See 4.4)

3.2.1 Accomplish liquid penetrant inspection of hard-faced metallic seats and discs in accordance with 2.a.

3.2.1.1 Acceptance criteria shall be in accordance with Section 7 of 2.b, except hairline cracks in hard-faced areas of seats and discs are acceptable provided the valve does not show evidence of leakage.

3.3 Repair valve as follows:

3.3.1 Straighten stems and pushrods to within 0.002 inch total indicator reading. Polish stems and pushrods to a 32 Root-Mean-Square (RMS) finish in way of packing or seal surfaces and remove raised edges and foreign matter.

3.3.2 Chase and tap exposed threaded areas.

3.3.3 Dress and true gasket mating surfaces.

3.3.4 Machine, grind, or lap and spot-in metallic discs to seats to obtain a 360-degree continuous contact.

(V)(G) "INSPECT CONTACT"

3.3.4.1 Inspect contact using blueing method.
Transfer line shall not exceed 1/16 inch in width.

3.4 Assemble valve installing new packing, gaskets, diaphragms, springs, and soft seats in accordance with manufacturer's specifications and new fasteners in accordance with Table One, or Table 2 for DDG 51 class.

3.5 Hydrostatically test valve as follows:

3.5.1 Hydrostatic test equipment shall have the following capabilities:

3.5.1.1 Manual overpressure protection release valve.

3.5.1.2 Self-actuated and resetting relief valve with a set point no greater than 100 PSIG above the test pressure or 10 percent above the test pressure, whichever is less.

3.5.1.3 Master and backup test gages with gage range and graduation shown on Table 3.

3.5.1.4 Protection equipment shall be accessible and test gages shall be located where clearly visible and readable to pump operator and inspector.

(V)(G) "SHOP TEST"

3.5.2 Test and set valve in shop.

3.5.2.1 Test shall be applied for a minimum of three minutes.

3.6 Attach a metal tag to valve, stamped with the following information:

3.6.1 Ship name and hull number.

3.6.2 Valve number or identification.

3.6.3 Valve regulation range and set point.

3.6.4 Date valve tested and set.

3.6.5 Name of repair facility.

4. NOTES:

4.1 Valve inlet, regulated pressure/temperature, and test medium will be designated in Work Item.

4.2 Nitrogen or air may be used for shop test of steam valves.

4.3 Repairs to pilot control will be specified in the invoking Work Item.

4.4 Documentation on the QA form is not required.

TABLE ONE

VALVE BODY MATERIAL

	<u>1/</u> Alloy Steel	Carbon Steel	<u>2/</u> Nonferrous
<u>3/</u> Studs and Bolts to MIL-S-1222	Grade B-16	Grade B-16	Phosphor Bronze - Any Grade Silicon Bronze - Any Grade Nickel Copper - Class A <u>4/</u>
Nuts to MIL-S-1222	Grade 4 or 7	Grade 4 or 7	Phosphor Bronze - Any Grade Silicon Bronze - Any Grade Nickel Copper - Class A or Class B <u>5/</u>
Socket Head Cap Screws	FF-S-86	FF-S-86	

1/ Alloy steel is of Composition A - 2-1/4 percent Chromium, one percent Molybdenum, Composition B - 1-1/4 percent Chromium, 1/2 percent Molybdenum, and Composition C - Carbon Molybdenum.

2/ Nonferrous Alloy except Aluminum.

3/ Studs shall be Class 2 or 3 fit on the nut end and Class 5 fit on the stud end, except that a Class 3 fit with a thread locking compound may be used where temperatures do not exceed 250 degrees Fahrenheit. The thread locking compound shall conform to MIL-S-22473. Inspect Class 3 fit stud ends in accordance with SAE-J2270.

4/ Fasteners of Nickel Copper Aluminum Alloy shall be the only type used on sea chests and hull valves.

5/ Nuts of Nickel Copper Alloy conforming to QQ-N-281 Class A or B, or Nickel Copper Aluminum conforming to QQ-N-286 shall be the only type used on sea chests and hull valves.

TABLE 2

VALVE BODY MATERIAL

	1/ Alloy Steel/Carbon Steel	2/ Nonferrous
3/ Studs and Bolts to MIL- S-1222	5/ For services up to and including 650 degrees Fahrenheit; Grade 5 steel	4/ 5/ Phosphor Bronze - Any Grade
	For services to 775 degrees Fahrenheit; Grade B7 or B-16	Silicon Bronze - Any Grade
	For services to 1,000 degrees Fahrenheit; Grade B-16	Nickel Copper - Class A
	For services in which JP-5, lubricating oil, or inflammable gas or liquid of any kind, regardless of pressure and temperature, which are within 3 feet of hot surfaces (above 650 degrees F) and where steel tubing is required; Grade 2, 5 or 8 steel	
	Bolting subject to sea water corrosion (other than hull integrity bolting; for hull integrity bolting see Note 4) Connections in contact with bilge regions. Where strength requires ferrous bolting and is exposed to the weather; Class A Nickel - Copper alloy to QQ-N-281 or silicon bronze to ASTM B98 with dimensions of MIL-S-1222. Where greater strength is required, use Nickel - Copper - Aluminum alloy QQ-N-286.	

TABLE 2 (CONT)

Nuts to MIL-S-1222	5/ For services up to and including 650 degrees Fahrenheit; Grade 5 steel	Phosphor Bronze - Any Grade
	For service to 775 degrees Fahrenheit; Grade 2H or 4 steel	Silicon Bronze - Any Grade
	For services to 1,000 degrees Fahrenheit; Grade 4 steel	Nickel Copper - Class A or Class B 4/ 5/
	For services in which JP-5, lubricating oil, or inflammable gas or liquid of any kind, regardless of pressure and temperature which are within 3 feet of hot surfaces (above 650 degrees F) and where steel tubing is required; Grade 5 or 8 steel	
	Nuts subject to seawater corrosion. Connections in the bilge regions. Where strength requires ferrous material and is exposed to the weather; Class A or B Nickel Copper Alloy to QQ-N-281 or Silicon Bronze to ASTM B98 with dimensions to MIL-S-1222	

NOTES

- 1/ Alloy steel is of Composition A - 2-1/4 percent Chromium, one percent Molybdenum, Composition B 1-1/4 percent Chromium, 1/2 percent Molybdenum, and Composition C - Carbon Molybdenum.
- 2/ Nonferrous Alloy except Aluminum.
- 3/ Studs shall be Class 2 or 3 fit on the nut end and class 5 fit on the stud end, except that a Class 3 fit with a thread locking compound may be used where temperatures do not exceed 200 degrees fahrenheit. The thread locking compound shall be in accordance with MIL-S-22473. Inspect Class 3 fit stud ends in accordance with SAE-J2270.
- 4/ Fasteners of nickel copper alloy shall be the only type used on sea chests and hull valves.
- 5/ Where these materials would constitute part of a galvanic couple, proposals for alternate materials shall be submitted for approval.

TABLE 3 - MASTER GAGE SELECTION FOR HYDROSTATIC TESTS

Maximum Test Pressure (lb/in ² g)		Master Gage Range*** (lb/in ² g)		Master Gage Maximum Graduation Size (lb/in ² g)
From*	To**	From	To	
5000	9500	0	10000	100
3000	5800	0	6000	30
2500	4800	0	5000	30
1500	2800	0	3000	20
1000	1800	0	2000	15
750	1300	0	1500	10
500	800	0	1000	10
250	500	0	600	5
			300	
150	250	0	200	2
100	175	0	160	2
75	125	0	100	1
50	80	0	60	1
20	50	0	30	0.5
10	25	0	15	0.2
7	10	0	10	0.1
5	7	0		0.1

NOTES:

1. Master gage and back-up gages shall track within two percent of each other.
 2. System maximum test pressures shall be determined by applicable overhaul specification, building specification, or other governing documents.
- * Values agree with the requirement that gage range shall not exceed 200 percent of maximum test pressure except for gage ranges 0 to 60 and below.
- ** Values allow for reading pressures up to relief valve setting.
- *** Exceptions to the values given in this table may be approved locally by Design, based on an evaluation of test pressure, gage range, and specific application.